

Date: Monday, 8/13/2007 3:45:19 PM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HINGE BRACKET		
Job Number	: 33882					
Estimate Number	: 10224					
P.O. Number	: N/A		Part Number	: D2143		
This Issue	: 8/13/2007 S.O. No. : N/A		Drawing Number	: D2143 REV. C1		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: C1		
Previous Run	: 31781		Material	: N/A		
Written By	<i>JLM 07-08-13</i>		Due Date	: 8/20/2007 Qty: 50 Um: Each		
Checked & Approved By						
Comment						
			EC			
Comment: Est C 00.05.18 Added inspection level 8 Est Rev:D Now on WaterJet 06-10-15 JLM						

Additional Product

Job Number:	
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Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S040 	5052-H32 .040 Sheet 
	Comment: Qty.: 0.0693 sf(s)/Unit Total : 3.4650 sf(s) Material: 5052-H32 (QQ-A-250/8) 0.040" thick (M5052H32S.040)	Batch: <i>M104921</i> <i>HB 07-08-14</i>
2.0	WATER JET 	FLOW WATER JET 
	Comment: FLOW WATER JET 1-Cut as per Dwg D2143 Dwg Rev: <i>C1</i> Prog Rev: <i>C1</i>	<i>HB 07-08-14</i> <i>52</i> <i>P+D</i>
	2-Deburr if necessary	
3.0	QC2 	INSPECT PARTS AS THEY COME OFF MACHINE <i>HB 07-08-14</i> 
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8 	SECOND CHECK 
	Comment: SECOND CHECK	<i>en 07/08/14</i> <i>52</i> <i>checked</i>
5.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr <i>→ SAM</i>	<i>07/08/14</i> <i>52</i> <i>checked</i>

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 33882

Part Number: D2143

Job Number:



Seq. #: Machine Or Operation:

Description:

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D2143

SB 07/08/2007

52

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/2007

QC5

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MJ

07-08-24

50

9.0 POWDER COATING POWDER COATING



M105068



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MJ

07/08/28

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

7/8/28 54



11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SJ210

PACKAGING RESOURCE #1

6 7/8/28 54



12.0 QC21 FINAL INSPECTION/W/O RELEASE



FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12 07/08/30

52

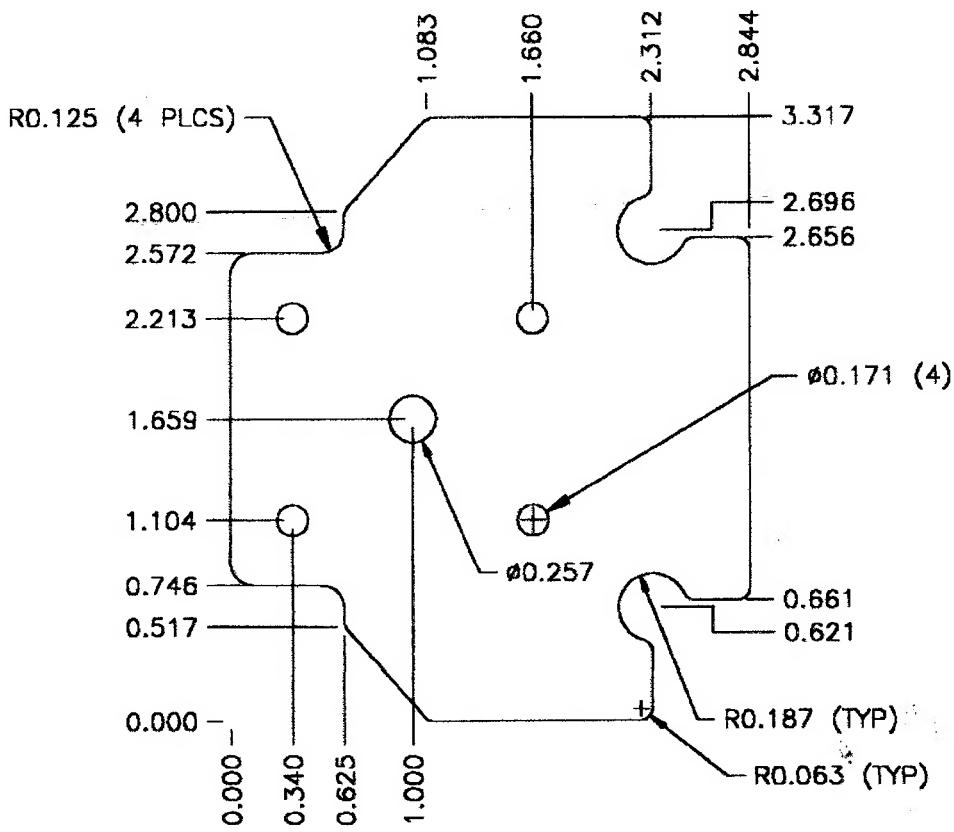
Job Completion



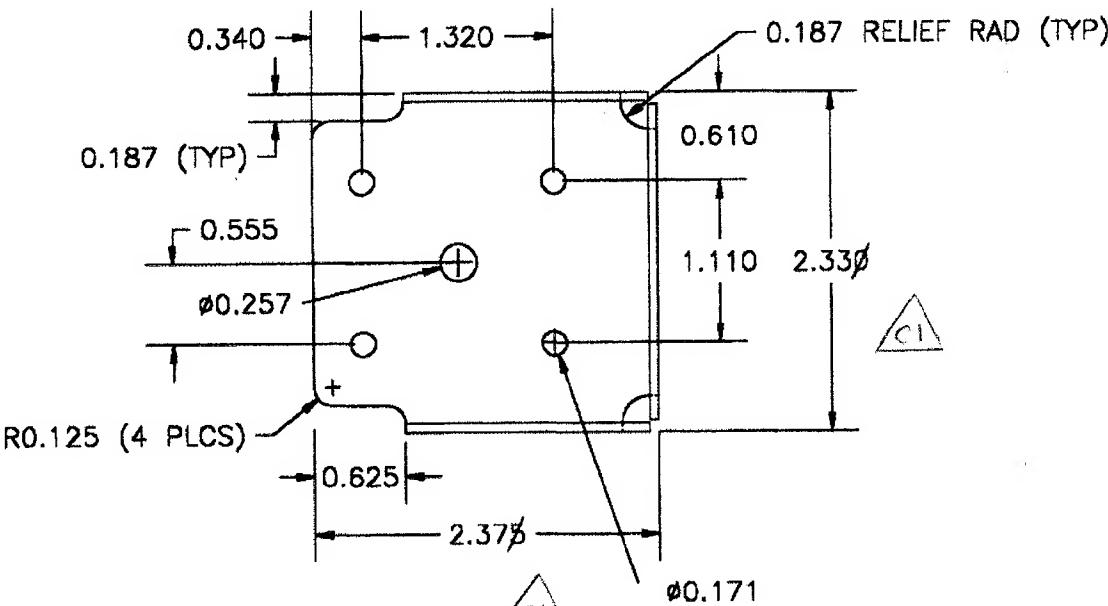
11 07/08/30

DART

DESIGN J. BRADLEY	DRAWN BY K. HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>Bob</i>	APPROVED <i>Bob</i>	DRAWING NO. D2143	REV. a SHEET 2 OF 2
DATE 95:10:18		TITLE HINGE BRACKET FLAT PATTERN	SCALE 1:1

RELEASED
9L 66 20 10

MATERIAL: 5052-H34, 0.040 THICK GRAIN ALONG 43.317



MATERIAL: 5052-H34, 0.040 THICK
FINISH: WHITE POWDER COAT HI-GLOSS

RELEASED
6/06/2013

DART
AEROSPACE



DESIGN	DRAWN BY	DART AEROSPACE LTD	
J. BRADLEY	K. HAND	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
B. (initials)	R. (initials)	D2143	SHEET 1 OF 2
DATE		92:07:10	SCALE
C1	APR 04 06 15	UPDATE DIMENSIONS	
		ADD FLAT PATTERN	
B	96.06.06	MATERIAL WAS 2024-T3 .063 THICK	
C	96.06.13		
		HINGE BRACKET	

DART AEROSPACE LTD	Work Order:	
Description: Hinge Bracket	Part Number:	D2143
Inspection Dwg: D2143	Rev: C1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

100

Measured by:	HB	Audited by:	EP	Prototype Approval:	N/A
Date:	07-08-14	Date:	07/08/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.11.11	New Issue	KJ/JLM	SJF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/08/14 07/08/14	21	Change grain direction on Drawing D2143 of 45° not along 3.317				✓ 07/08/14	EN 07/08/14

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/08/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries